



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-698-015
Job Sheet 171053



Part No: D412-698-015

Job Qty: 3 ea

Part Name: Door Support - V Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/26/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D412-698 REV.G IPP Rev:C Removed Manufacturing 06-01-25 JLM IPP Rev:D change to rev D ECN 1104
08-01-28 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	1/31/18	1/31/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	3 pcs	1/31/18	1/31/18	0.00	0.00	Packaging1-4		
120	QC	3 pcs	1/31/18	1/31/18	0.00	0.00	QC4		
125	DC	3 pcs	1/31/18	1/31/18	0.00	0.00	DC		
130	Packaging	3 pcs	1/31/18	1/31/18	0.00	0.00	Packaging3-2		
140	QC21-FG	3 Ea	1/31/18	1/31/18	0.00	0.00	QC21		

Part Op
Descriptions: 125 - Photocopy bluefile and create labels per PPP D412-698-015 CHG001

DAS
21
9-80

FEB 06 2018

FEB 12 2018

fgp3

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3200-1	Door Post Block	6 Ea (2 ea)	90-Start up Operation	
D3200-3	Door Wedge	6 Ea (2 ea)	90-Start up Operation	
D3201-1	Doubler	6 Ea (2 ea)	90-Start up Operation	
D3201-3	Angle	3 Ea (1 ea)	90-Start up Operation	
D3201-4	Angle	3 Ea (1 ea)	90-Start up Operation	
MS21042L3	Nut	36 Ea (12 ea)	90-Start up Operation	
MS24693-S277	Screw	36 Ea (12 ea)	90-Start up Operation	
NAS1149D0332J	Washer	36 Ea (12 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3200-1	6	14	0
	D3200-3	6	35	0
	D3201-1	6	13	0
	D3201-3	3	13	0
	D3201-4	3	14	0
	MS21042L3	36	2,520	0
	MS24693-S277	36	58	0
	NAS1149D0332J	36	4,498	0

Part Specifications

000 427

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Start up Operation CHG001 Job No: 171053 02/02/18 Change No: Operation: Revision: Original Serial #: S038448 D412-698-015 PART NO: Door Support - V Block S038448 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Completed By _____
	Lead hand / Supervisor Approval Verification _____
	QC / QA Coordinator Approval _____

Root Cause			
Environment ☐	No Re-verification ☐	Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐

Specifications could not be found.

Plex 1/26/18 10:14 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



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Master Unit 000427

Tel (613) 632-5200

Containers on Master Unit 000427				
Serial No	Part No	Customer Part No	Status	Quantity
F156307	D3200-1		Allocated	1
F162922	D3200-1		Allocated	5
F164930	D3200-3	D3200-3	Allocated	4
S034512	D3200-3	D3200-3	Allocated	2
F163468	D3201-3		Allocated	1
S034380	D3201-3		Allocated	2
S034375	D3201-4		Allocated	3
S034374	MS21042L3	MS21042L3	Allocated	36
S034368	NAS1149D0332J	NAS1149D0332J	Allocated	36

S039355x1

D3201-1 S031548x3 F164725x3
MS21042L3-277 S006157x11

x(25) S039359

(X1)

7.0 PARTS LIST – PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: G

Date: 17.11.23